

Date: Monday, 6/12/2006 3:26:45 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE  
 Job Number : 27491  
 Estimate Number : 10973  
 P.O. Number : N/A Part Number : D206667203  
 This Issue : 6/12/2006 S.O. No. : N/A Drawing Number : D206-667-243 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B  
 Previous Run : 27490 Material : N/A  
 Written By : *See Comment Below* Due Date : 7/15/2006 Qty: 1 Um: Each  
 Checked & Approved By : *06.06.13*  
 Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell  
 Skid tubes KJ/JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

KS 06.06.29

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6004-115

Crosstube

B23968

Check OD = 2.500" ID = 1.800"

BG 06.06.14

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089 N/A

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

MS 06.06.16

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06.06.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L AFT X-TUBE

Job Number: 27491

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Polish entire outside surface of crosstube

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

BG 06-06-19 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06-06-19 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/07/26 1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06-07-26

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

Pm 06-07-26

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-07-26 1

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

Pm 06-07-26 1

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206L AFT X-TUBE

Job Number: 27491

Part Number: D206667203

Job Number:



Seq. #

Machine Or Operation:

Description :

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

*Pmc*  
*06-07-31* ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*RM 06-07-31* ①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06-08-01* ①

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: *1757*

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*06/08/01* ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*06/08/02* ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:26:46 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 27491

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

025053

RT 06 08 04

19.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-043

Nut Plate

025052

RT 06 08 04

20.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number

Description Batch

14 MS20601AD4W10 Rivet

M19111

RT 06-08-06

(14)

MS20601AD4W9

M19191

PM 06-08-09

(14)

AFT

21.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

FC 06 08 03 (1)  
06-08-04 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-0002	22	Dot print at step 18. Perm. change					<i>[Signature]</i> 060002	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ET 06-08-08

24.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip 327545 ET 06-08-06

25.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch 818214

2 D2892-1 Support 31117 ET 06-08-04

26.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch M19391

4 MS21920-22 Clamp M19391 ET 06-08-04

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up. ET 06-08-06

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb ET 06-08-06

28.0

QC5

INSPECT WORK TO CURRENT STEP

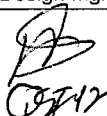


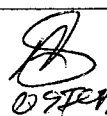
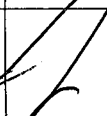



Comment: INSPECT WORK TO CURRENT STEP

ET 06-08-08 (1)

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
060809	28	Dwg deviation for hole orientation.		Re-work as per NCR 071 - see attached e-mail.	 06.08.09	 06.08.09	 06.08.09	 06.08.09

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/09

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:26:46 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 27491

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M19512

31.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101648

32.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt M116941

33.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt M101281

34.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer M101369

AL 06/08/08

W/O:		WORK ORDER CHANGES					
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:26:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 27491

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*C 206/08/08 ①*

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: \_\_\_\_\_

PPP Rev: C

*PS 06/08/10*

*AP 06/08/10*

*①*

37.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*D 06/08/31 ①*

Job Completion



*C 206/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**RELEASED  
05-07-26

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH =  $104.91 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27491

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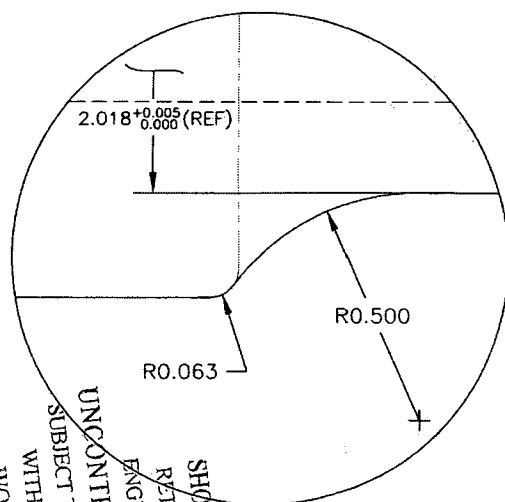
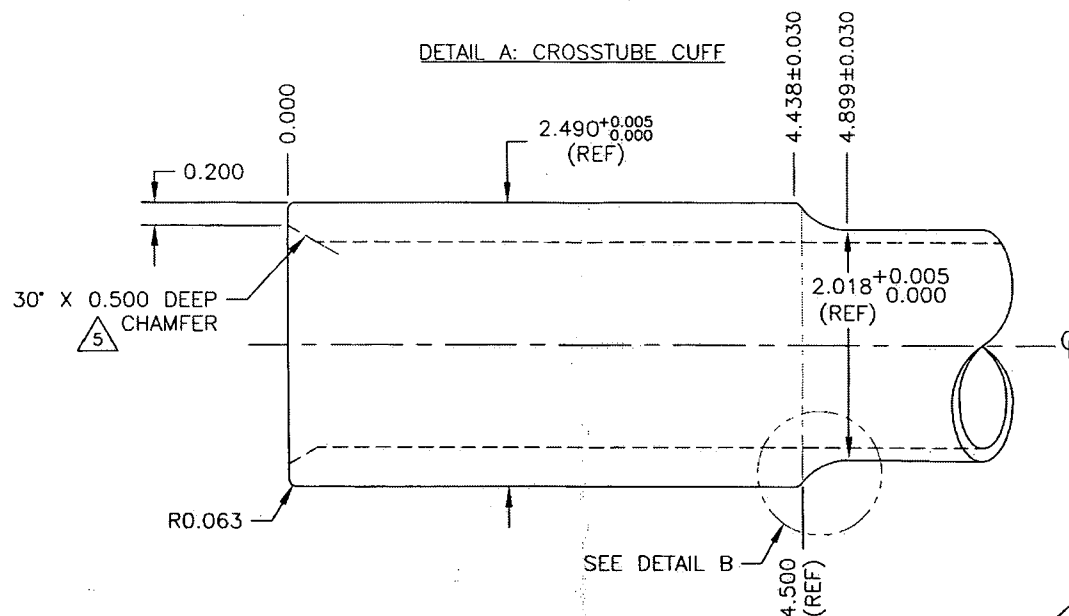
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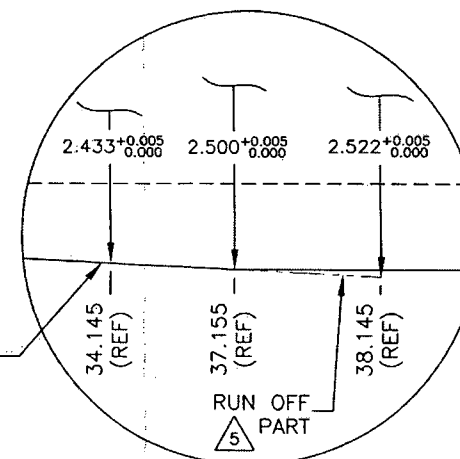


RELEASED  
05.07.26



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	DS	APPROVED	DS	DRAWING NO.	REV. B
		DATE	05.07.26			D206-667-243	SHEET 3 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206L HIGH AFT)	1:1

NO. 27491  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
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DART AEROSPACE LTD		Work Order:
Description: Crosstube Assembly		Part Number: 0206667203
Inspection Dwg: 0206667-243 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

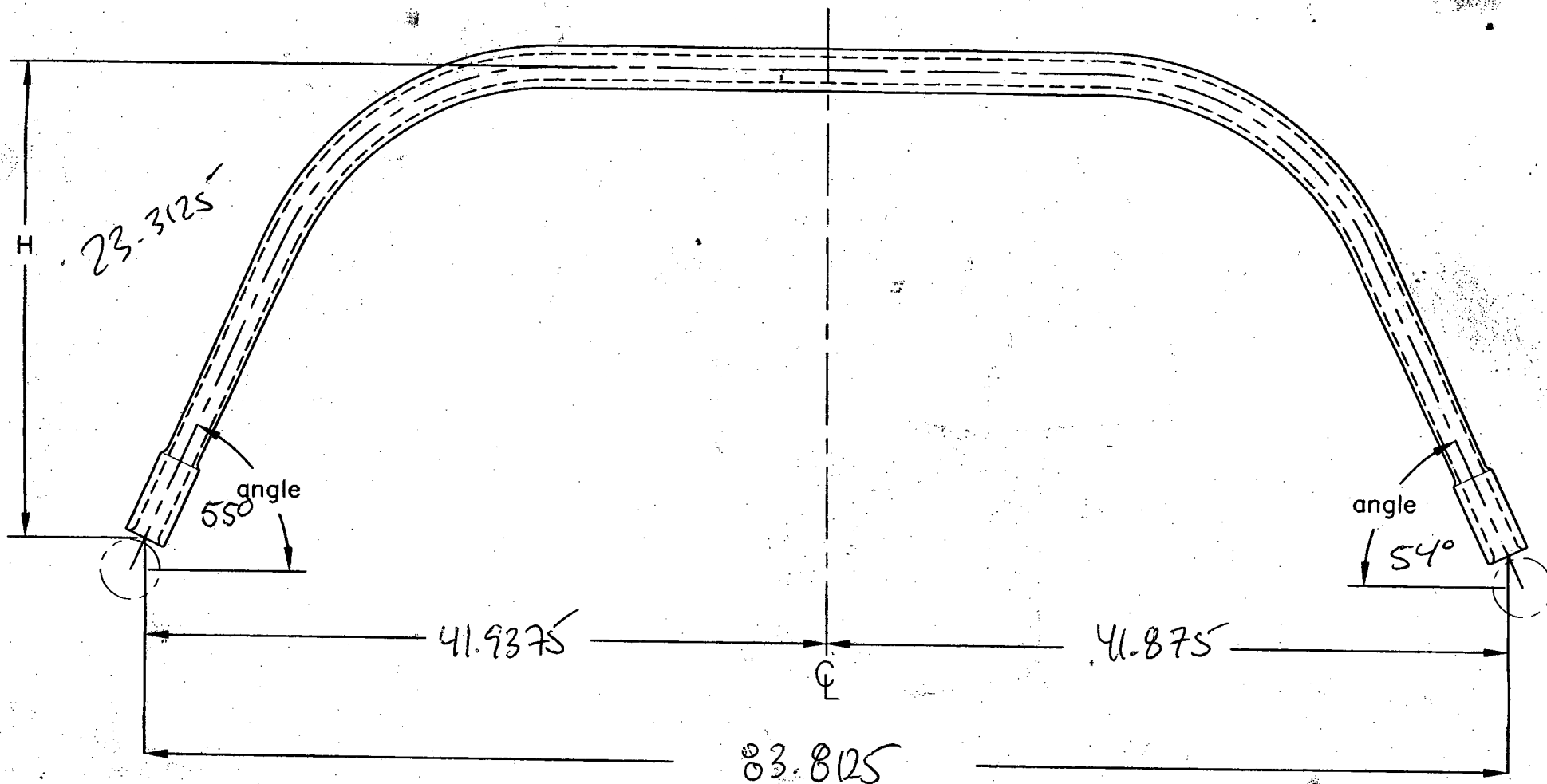
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005 -0.000	2.492	—		
	2.018	+0.005 -0.000	2.023	—		
	2.079	+0.005 -0.000	2.084	—		
	2.145	+0.005 -0.000	2.150	—		
	2.209	+0.005 -0.000	2.114	—		
	2.287	+0.005 -0.000	2.291	—		
	2.363	+0.005 -0.000	2.366	—		
	2.433	+0.005 -0.000	2.438	—		
	0.200	+/- 0.010	.200	—		
	0.500 X 30°	+/- 0.010	.500	—		
	R0.063	+/- 0.010	.063	—		
	R0.500	+/- 0.010	.500	—		
	4.438	+/- 0.030	4.438	—		
SIDE B	104.91	+/- 0.020	104.89	✓		
	2.490	+0.005 -0.000	2.492	—		
	2.018	+0.005 -0.000	2.022	—		
	2.079	+0.005 -0.000	2.083	—		
	2.145	+0.005 -0.000	2.148	—		
	2.209	+0.005 -0.000	2.213	—		
	2.287	+0.005 -0.000	2.290	—		
	2.363	+0.005 -0.000	2.368	—		
	2.433	+0.005 -0.000	2.435	—		
	0.200	+/- 0.010				
	0.500 X 30°	+/- 0.010				
	R0.063	+/- 0.010				
	R0.500	+/- 0.010				
	4.438	+/- 0.030				

Measured by: MR 18G	Audited by: J.G	Prototype Approval:	N/A
Date: 06/06/16	Date: 06/07/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.12.12	New Issue	KJ/RF	





DATE: 06-07-26

DESCRIPTION: D206-667-203

BATCH NO: B27491

DRAWING: D206-667-243 Rev B

H: 23.52 *t. 000*

1/2 SPAN: 41.92

TOTAL SPAN: 83.84

ANGLE: 54° ± 2°

*J*  
*060726*

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# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34601

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of four (4) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D206-667-103 S/N's B26702 & B26704

Qty. (2) P/N D206-667-203 S/N's B27491 & B27492



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on four (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH~~  
~~THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY: 

DATE August 1, 2006

INSPECTION  
STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER 00001757

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT





**Peter Hum**

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** August 8, 2006 4:34 PM  
**To:** 'Peter Hum'  
**Cc:** 'Bill Beckett'; 'Serge Shahbazian'  
**Subject:** FW: re-work of 206B and 206L and 407 crosstubes

Peter,

You will also have to remove and re-install the top clamps in the proper orientation.

David

---

**From:** David Shepherd [mailto:dshepherd@dartaero.com]  
**Sent:** Tuesday, August 08, 2006 2:11 PM  
**To:** 'Peter Hum'  
**Cc:** 'Bill Beckett'; 'Serge Shahbazian'  
**Subject:** RE: re-work of 206B and 206L and 407 crosstubes

As discussed, this is an acceptable repair scheme for these crosstubes.

David

---

**From:** Peter Hum [mailto:phum@dartaero.com]  
**Sent:** Tuesday, August 08, 2006 1:16 PM  
**To:** 'David Shepherd'  
**Cc:** Bill Beckett; Serge Shahbazian  
**Subject:** re-work of 206B and 206L and 407 crosstubes

David,

With respect to current stock of the 206B, 206L and 407 crosstubes:

It appears the holes for OEM compatibility were drilled on the incorrect sides (i.e. sides requiring 3 holes only have 2; and sides requiring 2 holes have 3); additionally the nut plates are oriented incorrectly

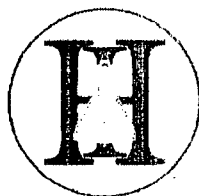
To correct this problem is it acceptable to perform the following

- 1) The D2873-043/-045 radius blocks are installed on the incorrect sides. Remove the D2873-043/-045 radius blocks from all cuffs
- 2) Drill the required hole for the fwd side of the cuff and install the D2873-043 radius block
- 3) Install the required D2873-045 radius block on the aft side of the cuffs\*\*\*

\*\*\*On all affected installations, an extra hole will be present on the aft side of all of the cuffs; affected customers/stock will receive a DSI indicating this.

Peter

10/08/2006



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. No **34601**

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT/COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG.

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of four (4) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D206-667-103 S/N's B26702 & B26704

Qty. (2) P/N D206-667-203 S/N's B27491 & B27492



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



BODY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on four (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

  
S. FLETCHER

DATE: August 1, 2006

INSPECTION  
STAMP(S)

Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER: 00001757

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

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